

# Work Order ID 58885

May 19, 2010 10:53:59 AM

Page 1

Item ID: D4098-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Armrest Cushion Assembly

Start Date: 5/19/10 Start Qty: 5.00

Cust Item ID:

Required Date: 5/20/10 Req'd Qty: 5.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4098

A

124

0.00



Small Fab

Small Fab

Memo

PULL FROM STOCK

5 X D3780-041 B ~~44555~~

RE-IDENTIFY AS D4098-041

USING NEW B/N

PER ECN10-573

B 46 027 43 0.00

B 44534 2

12/05/19

5

126

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Memo

0.00

8.06719

15

# Work Order ID 58885



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Item ID:	D4098-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Armrest Cushion Assembly					
Start Date:	5/19/10	Start Qty:	5.00		Cust Item ID:	
Required Date:	5/20/10	Req'd Qty:	5.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging Packaging	Identify as per dwg & Stock Location:	0.00							
	Memo	0.00							
140  QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							
	Memo	0.00							

*261*  
*5/10/19*

*10-5-20*

*SL* *(SW)*

*10/05/20* *[Signature]*

*u 10/05/20*

# Picklist Print

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Work Order ID: 58885



Parent Item: D4098-041



Parent Item Name: Armrest Cushion Assembly

Start Date: 5/19/10

Required Date: 5/20/10

Comments: IPP Rev:A as per ECN10-573 DD 10.05.18 verf:EC

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
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D3780-041

Manufactured

No

Each

6.0000



Armrest Assembly



B46027 SP 12/05/10  
B44534

Location

Loc Qty

Loc Code

ST261

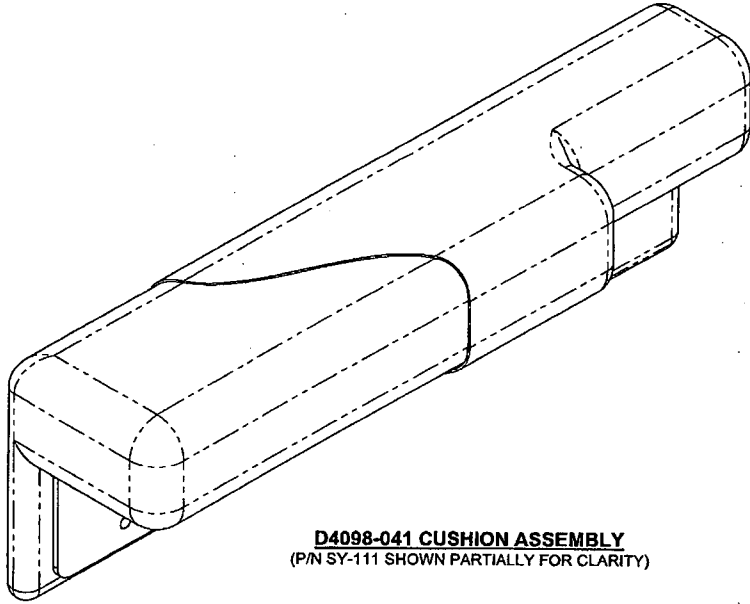
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56891

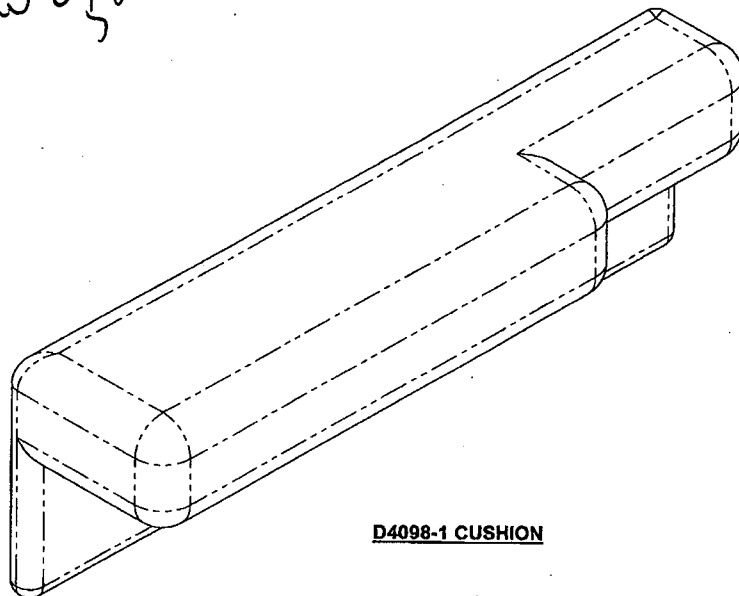
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8 7 6 5 4 3 2 1

*W 5885*



**D4098-041 CUSHION ASSEMBLY**  
(P/N SY-111 SHOWN PARTIALLY FOR CLARITY)



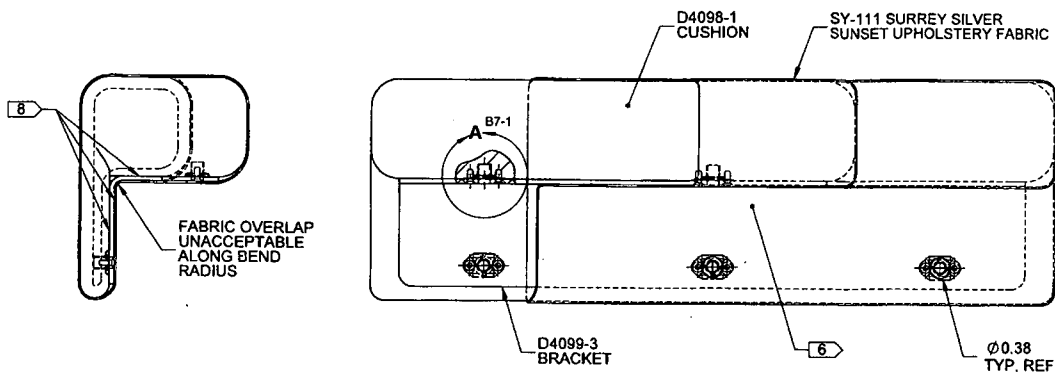
**D4098-1 CUSHION**

**RELEASED**  
2010-05-17

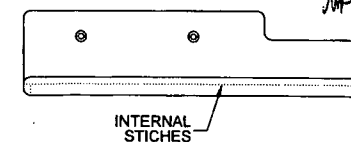
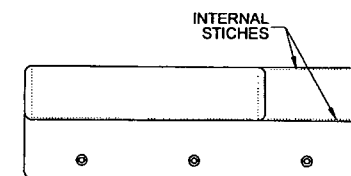
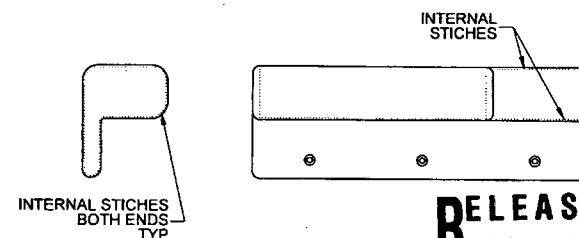
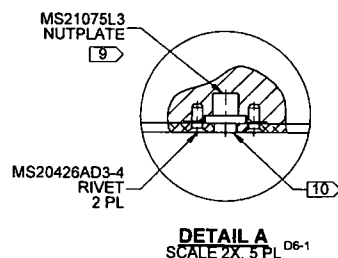
A	NEW ISSUE	DESCRIPTION	MB	10.05.05
REV.			BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4098</b> TITLE <b>CUSHION ASSEMBLY</b> REV. A SHEET 1 OF 3 SCALE NTS		
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
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ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4098-041	CUSHION ASSEMBLY
2	1	D4098-1	CUSHION
3	1	D4099-3	BRACKET
4	A/R	1300/1300L	3M SCOTCH-GRIP ADHESIVE
5	5	MS21075L3	NUT PLATE
6	10	MS20426AD3-4	RIVET
7	A/R	SY-111	SURREY SILVER SUNSET UPHOLSTERY FABRIC



**D4098-041 CUSHION ASSEMBLY**  
(P/N SY-111 SHOWN PARTIALLY FOR CLARITY)

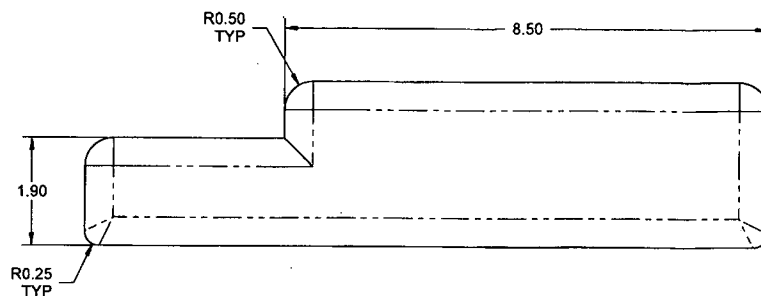


**D4098-041 CUSHION ASSEMBLY**  
**STITCHING PATTERN**

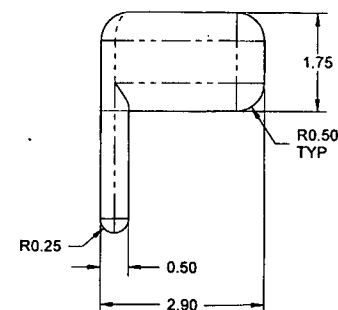
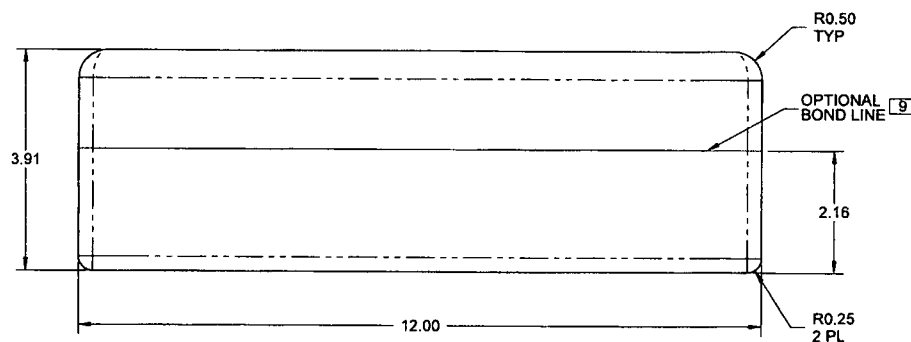
**D4098-041 NOTES:**

- 1) MATERIAL: COVER D4098-1/D4099-3 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111. BOND FABRIC TO D4099-3 USING 3M 1300/1300L ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS. THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4098-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.69 lbs
- 8) BOND D4098-1 CUSHION TO D4099-3 BRACKET USING 3M 1300/1300L ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 9) IT IS ACCEPTABLE TO RELIEVE D4098-1 CUSHION WHERE THE NUTPLATES ARE LOCATED TO ENSURE PROPER CONTACT WITH D4099-3 BRACKET
- 10) HOLES MUST BE FREE OF ADHESIVE AND FABRIC

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APPROVED	1/8	TITLE <b>CUSHION ASSEMBLY</b>	SCALE NTS
DE APPR.	1/8		
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*W/O 58885*



**D4098-1 CUSHION**

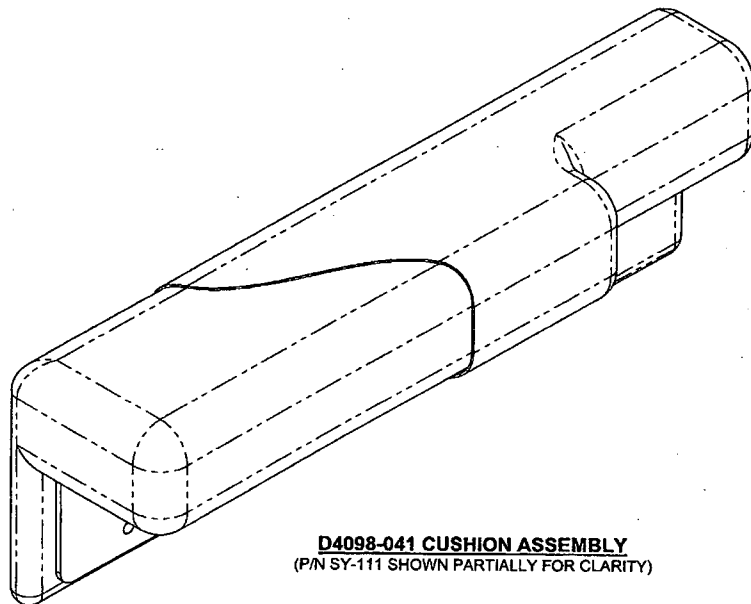
**RELEASED**  
2010-05-17

**D4098-1 NOTES:**

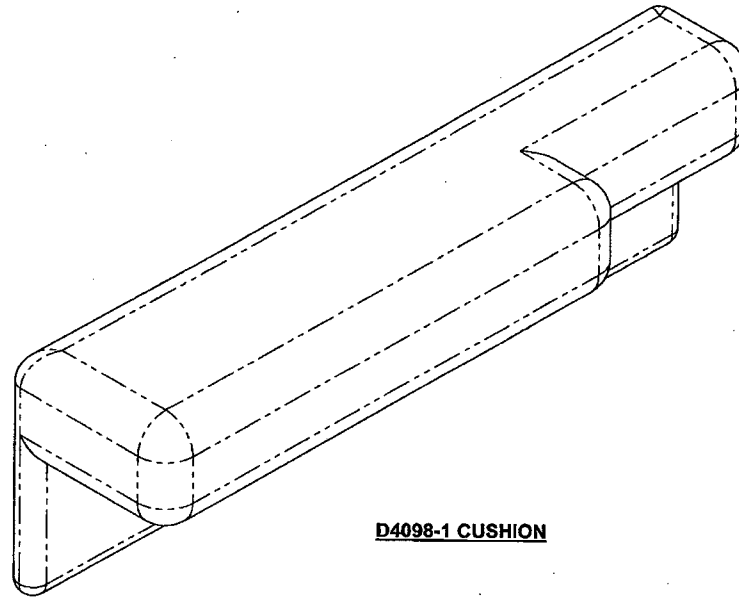
- 1) MATERIAL: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.37 lbs
- 8) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.
- 9) CUSHION MAY BE ASSEMBLED BY BONDING A 1.75" PIECE OF FOAM TO A 2.13" PIECE OF FOAM AS SHOWN ABOVE USING 3M 1300/1300L SCOTCH-GRIP ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

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MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>CUSHION ASSEMBLY</b>	NTS
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**D4098-041 CUSHION ASSEMBLY**  
(P/N SY-111 SHOWN PARTIALLY FOR CLARITY)



**D4098-1 CUSHION**

*Clear*

58885

**RELEASED**  
2010-05-17

A	NEW ISSUE	MB	10.05.05
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4098	SHEET 1 OF 3
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